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D3913-041
Job Sheet 188194



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 3/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/4/19	3/4/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs	3/4/19	3/4/19	0.00	10.00	Large Fab 1		
110	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC9		
120	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC5		
125	HandFinish	1 pcs	3/4/19	3/4/19	0.00	0.29	HandFinish2		
130	Powdercoat	1 pcs	3/4/19	3/4/19	0.00	0.93	Powdercoat2		
135	Packaging	1 pcs	3/4/19	3/4/19	0.00	0.00	Packaging1		
140	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC3		
150	HandFinish	1 pcs	3/4/19	3/4/19	0.00	0.50	HandFinish4		
160	QC	1 pcs	3/4/19	3/4/19	0.00	0.00	QC5		
170	Packaging	1 pcs	3/4/19	3/4/19	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea	3/4/19	3/4/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

4138997 START: 10:30 TEMP: 400 FINISH: 11:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	5143339
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5138226
D3913-15	Wide Handle Plate	1 pcs (1 ea)	90-Start up Operation	5143390
D3913-3	Rib	1 pcs (1 ea)	90-Start up Operation	5139345
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5141813
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5133177
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5144526
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5144629
D4016-1	Hinge Half, Base	3 pcs (3 ea)	90-Start up Operation	5115309
D4017-7	Rib	3 pcs (3 ea)	90-Start up Operation	x2 5123991 x1 5141346
D4017-9	Rib	2 pcs (2 ea)	90-Start up Operation	5141346

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			

Entered: _____ Date: _____



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